

ASAP

Work Order ID 101994

\*101994\*

May-22-13 10:59:22 AM

Item ID: D4771-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Wearplate

Start Date: 5/22/13 Start Qty: 2.00 \*2\*

Cust Item ID:

Required Date: 5/24/13 Req'd Qty: 2.00 \*2\*

Customer:

Reference:

Approvals: Process Plan: W Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4771	A								

100

0.00

\*100\*

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per dwg

prog rev: A

dwg rev: A

2-Deburr if required

2 0 Jm13-5-22

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

2 0 Jm13-5-22

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\*101994\*

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

\*130\*

Small Fab

Memo

0.00

Small Fab

Form as per dwg D4771

140

QC5- Inspect part completeness to step on W/O

0.00

\*140\*

QC

Memo

0.00

Quality Control

0.00  
2.00  
13.5.23

0.00  
2.00  
13.5.27

2

2

2

DB  
13/05/27

# Work Order ID 101994

**\*101994\***

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May-22-13 10:59:22 AM

Item ID: D4771-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Wearplate

Start Date: 5/22/13 Start Qty: 2.00 **\*2\***

Cust Item ID:

Required Date: 5/24/13 Req'd Qty: 2.00 **\*2\***

Customer:

Reference:

Run Start **\*NR1\***

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <i>W/A 001</i>	0.00							
<b>*150*</b>									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

*2 62 13-5-29*

*13/5/31*

*MF 13-5-30*

# Picklist Print

May-22-13 10:59:22 AM

Page 1

Work Order ID: 101994

Parent Item: D4771-1

Parent Item Name: Wearplate

Start Date: 5/22/13

Required Date: 5/24/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 13.03.27 NEW ISSUE DD VERF:JLM

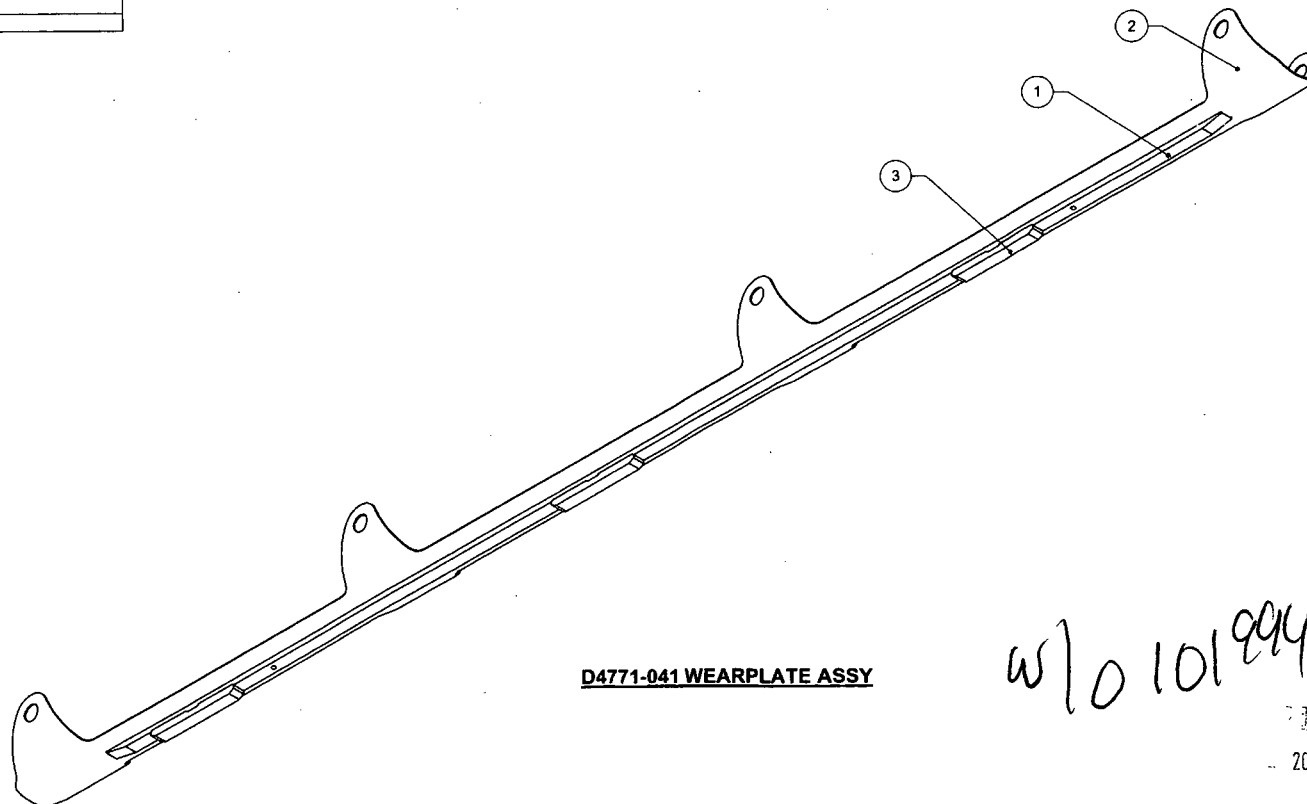
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA 304/316 .050 Sheet		Purchased	No				sf	351.1699		6.568421 6.6			

JmB-522

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT019	256.8	
117188	5	
117766	5	
120604	5	
122325	3	
123155	3	
124572	153.8	
125552	82	
MAT020	94.369894	
120243	2	
121626	1.529894	
124029	90.84	

125552

ITEM	QTY	P/N	DESCRIPTION
	X	D4771-041	WEARPLATE ASSY
1	1	D4770-5	BAR
2	1	D4771-1	WEARPLATE
3	A/R	2059B	HARDCOAT

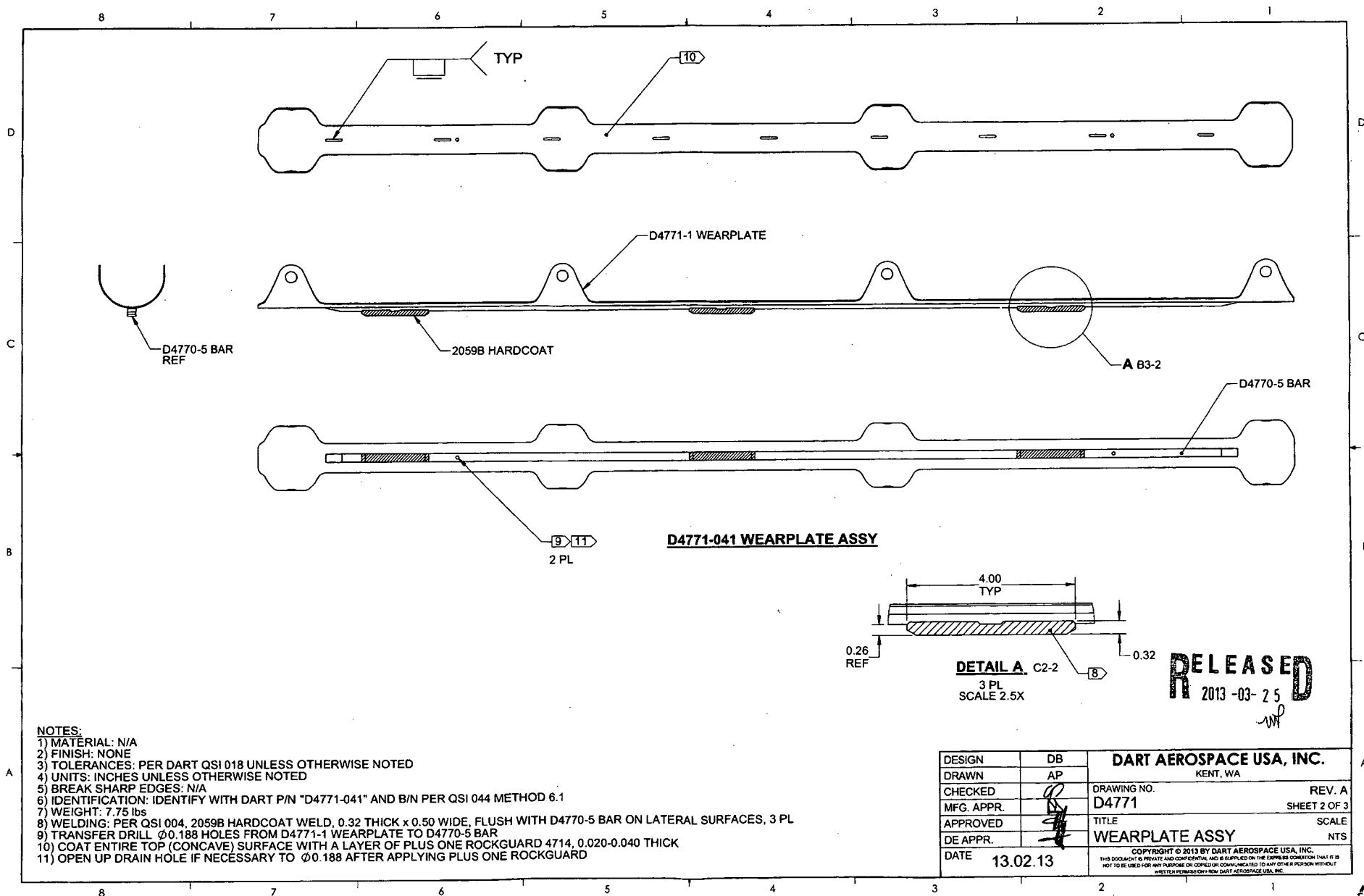


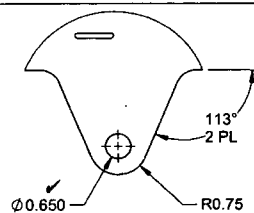
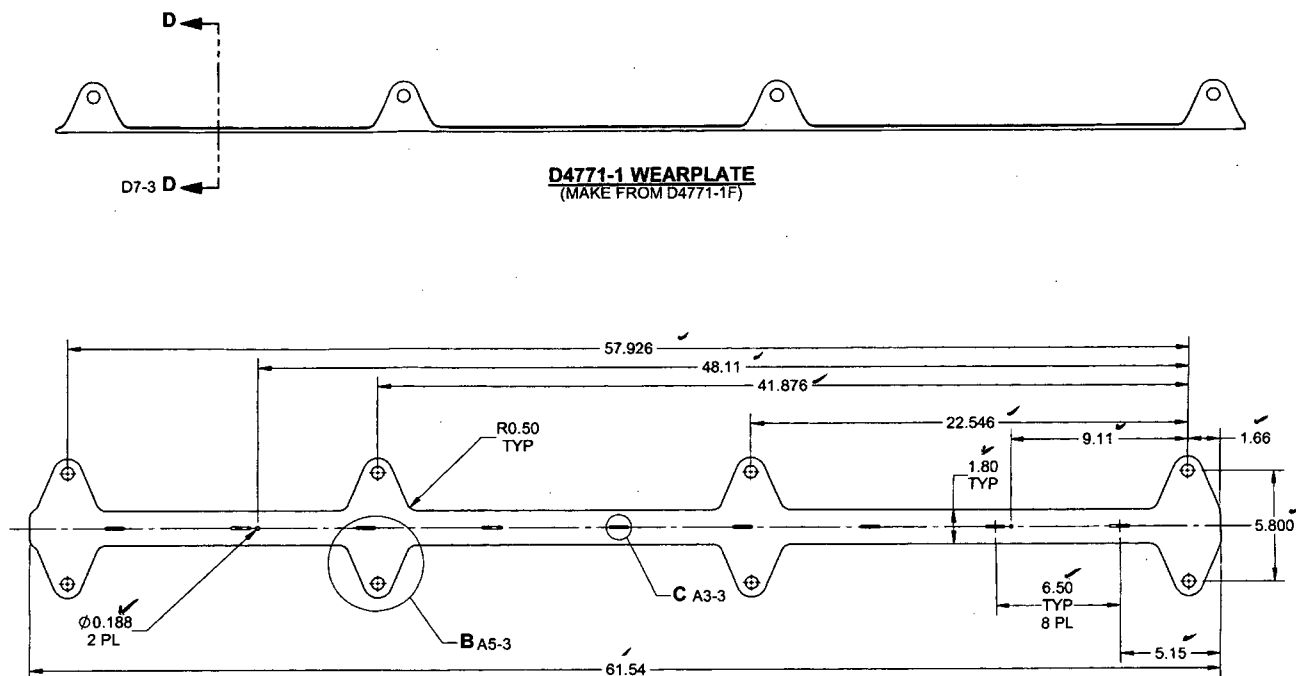
**D4771-041 WEARPLATE ASSY**

W/O 101994

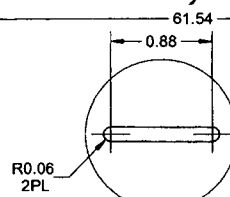
PLEASED  
2013-03-25

A	NEW ISSUE	AP	13.02.13
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4771	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	13.02.13	<small>COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	





**DETAIL B** B4-3  
8 PL  
SCALE 2X



**DETAIL C** C4-3  
9 PL  
SCALE 2X

**D4771-1F WEARPLATE**  
(FLAT PATTERN)

RELEASED  
2013-03-25

**NOTES:**

- NOTES:**
- 1) MATERIAL : AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524  
OR ASTM A240 OR ASME SA240  
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
  - 2) FINISH : NONE
  - 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS : INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION : NONE
  - 7) WEIGHT : 2.95 lbs
  - 8) IT IS ACCEPTABLE TO OVERBEND D4771-1 UP TO 2 DEG OR UNDERBEND UP TO 5 DEG

DESIGN	DB	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	AP	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4771	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSY	NTS
DATE	13.02.13	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE USA, INC. THIS DOCUMENT IS NOT TO BE USED FOR ANY PURPOSES, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY.</small>	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 101994
<b>Description:</b> Wear plate		<b>Part Number:</b> 14771-1
<b>Inspection Dwg:</b> 04771 Rev: A		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.188"	+0.005"-0.001"	0.190"	-		V	Jkmd1
Ø 0.650"	+0.008"-0.001"	0.654"	-		V	
0.88"	+/-0.030"	0.881"	-		V	
5.800"	+/-0.010"	5.800"	-		V	
7.30"	+/-0.030"	7.294"	-		V	
1.66"	+/-0.030"	1.66"	-		V	
9.11"	+/-0.030"	9.115"	-		V	Produce
22.546"	+/-0.010"	22.546"	-		T	Jkmd6
41.876"	+/-0.010"	41.876"	-		T	
48.11"	+/-0.030"	48.11"	-		T	
57.926"	+/-0.010"	57.926"	-		T	
61.54"	+/-0.030"	61.54"	-		T	
5.15"	+/-0.030"	5.151"	-		V	
6.50"	+/-0.030"	6.501"	-		V	
1.80"	+/-0.030"	1.808"	-		V	
0.050"	+/-0.010"	0.047"	-		V	

<b>Measured by:</b> JM	<b>Audited by:</b> <sup>27</sup>	<b>Preliminary Approval:</b>
<b>Date:</b> 13-5-22	<b>Date:</b> 13-5-23	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15